



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4149-041
Job Sheet 174864



Part No: D4149-041

Job Qty: 6 ea

Part Name: Aft Crosstube Lug Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/22/18

Job Tracking No:

Due Date: 3/29/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV C IPP Rev:A 10.06.24 new issue DD ver:EC IPP Rev:B 10.07.22 as per revB DD ver:JLM IPP Rev:C 11.03.03 as per revC DD ver:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	3/28/18	3/28/18	0.00	0.00	Start Up Small Fab-3		APR 12 2018
100	Small Fab	6 pcs	3/29/18	3/29/18	0.00	1.50	Small Fab-6		APR 18 2018
110	QC	6 pcs	3/29/18	3/29/18	0.00	0.00	QC5		APR 19 2018
120	Packaging	6 pcs	3/29/18	3/29/18	0.00	0.00	Packaging3-2		APR 19 2018
130	QC21-SA	6 Ea	3/29/18	3/29/18	0.00	0.00	QC21		APR 20 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3C12A	Bolt	12 Ea (2 ea)	90-Start up Operation	5057518
AN4C13A	Bolt	18 Ea (3 ea)	90-Start up Operation	5054186
D3910-1	Crosstube Lug	6 Ea (1 ea)	90-Start up Operation	5038203
D4091-1	Mounting Lug	6 Ea (1 ea)	90-Start up Operation	5040691
D4149-1	Crosstube Lug Plate, Aft	12 Ea (2 ea)	90-Start up Operation	5058295
D4149-3	Spacer	6 Ea (1 ea)	90-Start up Operation	50526159
D4149-5	Eyebolt Stud	6 Ea (1 ea)	90-Start up Operation	5055674
MS20615-4M18	Rivet	18 Ea (3 ea)	90-Start up Operation	5058182x
MS21043-3	Nut	12 Ea (2 ea)	90-Start up Operation	5035569
MS21043-4	Nut	18 Ea (3 ea)	90-Start up Operation	504688x2
NAS1149C0332R	Washer	24 Ea (4 ea)	90-Start up Operation	5038086
NAS1149C0432R	Washer	36 Ea (6 ea)	90-Start up Operation	5047834
				5025247



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Container No: S060313



Part: D4149-041

Job No: 174864

Serial No/Batch: S060313

Revision:
Inspector:

602447

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3C12A	12	125	0
	AN4C13A	18	49	0
	D3910-1	6	25	0
	D4091-1	6	34	0
	D4149-1	12	9	0
	D4149-3	6	0	0
	D4149-5	6	7	0
	MS20615-4M18	18	273	0
	MS21043-3	12	951	0
	MS21043-4	18	632	0
	NAS1149C0332R	24	4,896	0
	NAS1149C0432R	36	2,911	0
Part Specifications				
Specifications could not be found.				

Plex 3/22/18 11:37 AM dart.lacelle.linda

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
002447	S060312	AN3C12A	Bolt	s057518	ST349	12
002447	S060311	AN4C13A	Bolt	s054186	ST344	18
002447	S060310	D3910-1	Crosstube Lug	s038203	ST525	6
002447	S060309	D4091-1	Mounting Lug	s040691	ST525	6
002447	S060307	D4149-1	Crosstube Lug Plate, Aft	s058295	ST080	12
002447	S060306	D4149-3	Spacer	s056159	ST080	6
002447	S060303	D4149-5	Eyebolt Stud	s055674	ST081	6
002447	S060305	MS20615-4M18	Rivet	s058182	ST306	18
002447	S016882	MS21043-3	Nut		ST302	2
002447	S060301	MS21043-3	Nut	s035569	ST302	10
002447	S060300	MS21043-4	Nut	s038086	ST302	18
002447	S060299	NAS1149C0332R	Washer	s049837	ST266	24
002447	S060297	NAS1149C0432R	Washer	s025742	ST266	36

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 4/12/18 9:06 AM dart.quirion.sonia